

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009347**Date Inspected:** 20-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li zhi jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 06

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as West Tower 135M Flange. The weld designations reviewed are as follows:

(WSD1-DPSA4-6A/B-003,005,026)

(WSD1-SA4-50-003,005,006)

(WSD1-DPSA4-6B/B-002,027)

(WSD1-DPSA4-6A/B-011,010,006,014,018)

(WSD1-DPSA4-6B/B-007) Rejectable Indication found by MT method.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 02

Flux Cored Arc Welding Process:

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Welding of weld joint –027,010 located on PCMK FB3083-002. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –045,010 located on PCMK FB3019-001. Welder is identified as 045280. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –022,023 located on PCMK FB3019-001. Welder is identified as 062438. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

OBG # BAY 03

Flux Cored Arc Welding Process:

Welding of weld joint –012 located on PCMK LD002-044. Welder is identified as 051356. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-P4-F.

Welding of weld joint –012 located on PCMK LD001-046. Welder is identified as 051356. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-P4-F.

TOWER # East Lift 1 (OPEN YARD)

During random verification Magnetic Particle Testing of Tower East Lift 1 Skin C Plate and Skin C Stiffener Weld buttering location; QA Inspector discovered 20mm, 6mm, and 5mm long linear indication. These areas previously tested and accepted by ZPMC Quality Control MT Technician. The QA Inspector informed that the QA Inspector will be issuing incident reports which have linear indication.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

The QA Inspector informed ZPMC QC Mr. Zhao chen sun that the QA Inspector performed Magnetic particle Test of weld WSD1-DPSA4-6B/B-007 that weld have linear indication. The QA Inspector informed that the QA Inspector will be issuing incident report weld which have linear indication.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Sukanthan,Dhanasingh

Quality Assurance Inspector

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**Reviewed By:** Whitehead,Lonnie

QA Reviewer